

Order 12325



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4379-5
Job Sheet 188974



Part No: D4379-5

Part Name: Wearplate Cup

Job Qty: 120 ea



Part Weight: 0 lbs

Priority: Medium

Job Created: 1/17/19

Status: New

Due Date: 2/3/19

Job Tracking No:

Type: SOLD

Created By: Dara Macdonald

Description:

Note: DWG REV D SHEET 3 IPP REV A NEW ISSUE 14-04-01 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	120 Ea	2/3/19	2/3/19	0.00	0.00	Start Up Machining-3		
100	Doosan	120 pcs	2/3/19	2/3/19	0.02	15.52	Doosan		
120	QC	120 pcs	2/3/19	2/3/19	0.00	0.00	QC8		
130	Packaging	120 pcs	2/3/19	2/3/19	0.00	0.00	Packaging3-2		
140	QC21-SA	120 Ea	2/3/19	2/3/19	0.00	0.00	QC21		

Part Op 100 - turn as per Dwg and folio FB300
Descriptions: 130 - LOCATION: WA001-15

21 FEB 01 2019
9:39

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	4.9200 ft (041 ea)	90-Start up Operation	SB88602

Job Allocations

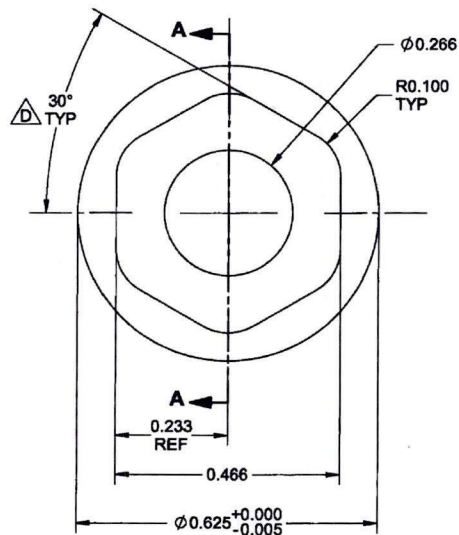
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	5	38	0

8.75

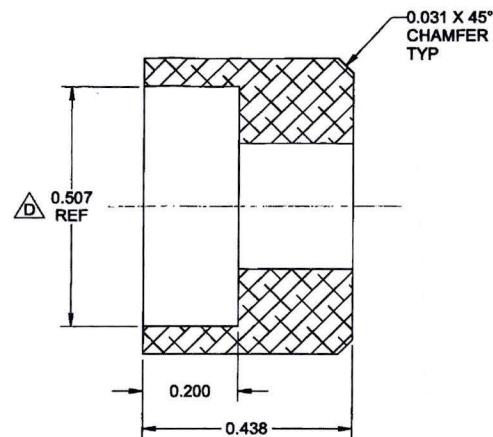
1178
2058
534 =
-1238

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	.8725
2	Wearplate Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	.267
3	Wearplate Cup	0.466Inches ± 0.010	0.476 0.456		.464
4	Wearplate Cup	0.353Inches ± 0.010	0.363 0.343		.353
5	Wearplate Cup	0.031Inches ± 0.010	0.041 0.021		1/32
6	Wearplate Cup	45.000Degrees ± 0.500	45.500 44.500	Angle	45
7	Wearplate Cup	0.200Inches ± 0.010	0.210 0.190		.201
8	Wearplate Cup	0.507Inches ± 0.010	0.517 0.497		.504

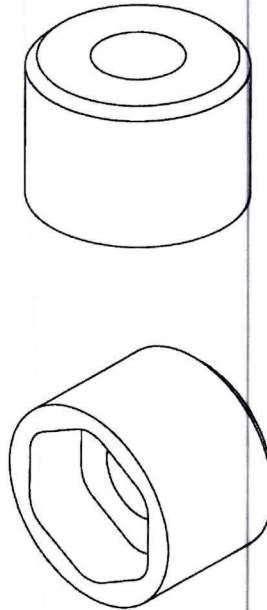
Plex 1/17/19 10:08 AM Dart.Macdonald.Dara



D4379-1 WEARPLATE CUP



SECTION A-A

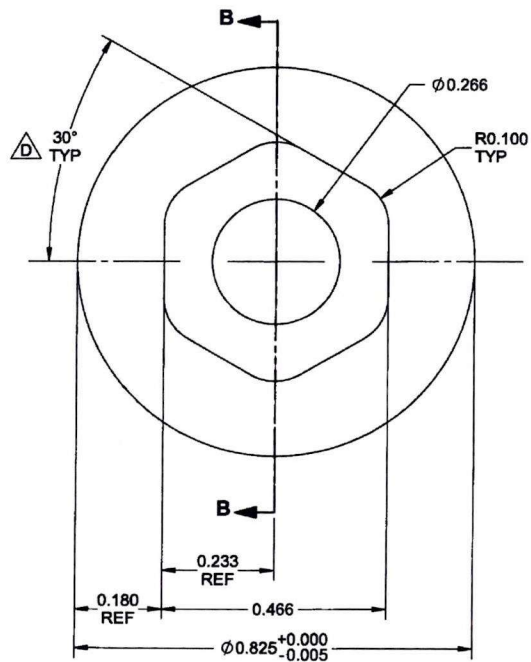


- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

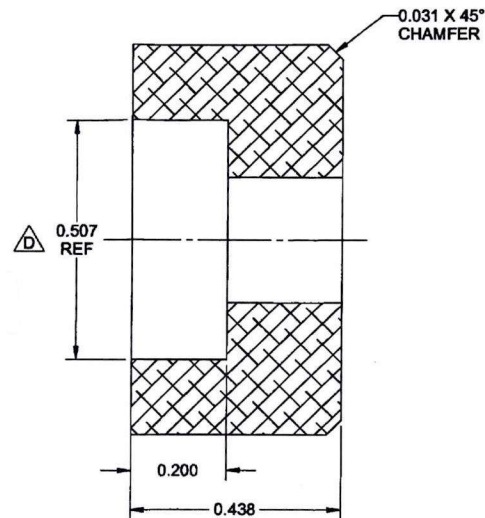
RELEASED
2016-02-23
EEN 16-519

APPROVED

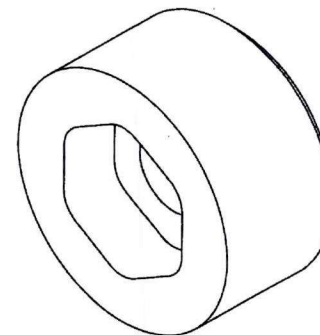
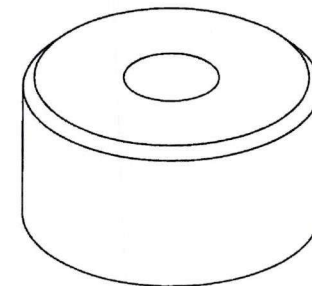
REV.	DESCRIPTION	BY	DATE
D	ADDED -7 SEE CIR 15-44. 30° ANGLE DIMENSION ADDED TO ALL PARTS 0.507 DIMENSION CHANGED TO REF.	AJS	15.12.17
C	ADD D4379-5 WEARPLATE CUP	DB	14.03.19
B	ADD D4379-3 WEARPLATE CUP	AP	12.07.04
A	NEW ISSUE	AJS	11.03.22
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4379 TITLE WEARPLATE CUP COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AJS		
CHECKED	ML		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS	REV. D	
DATE	15.12.17	SHEET 1 OF 4	
		SCALE NTS	



D4379-3 WEARPLATE CUP



SECTION B-B



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

RELEASED
2016-02-23

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4379	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE CUP	NTS
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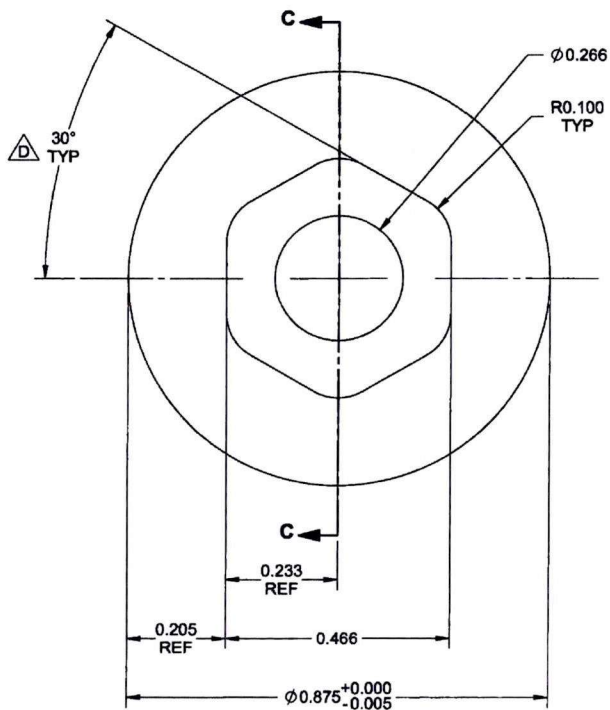
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D

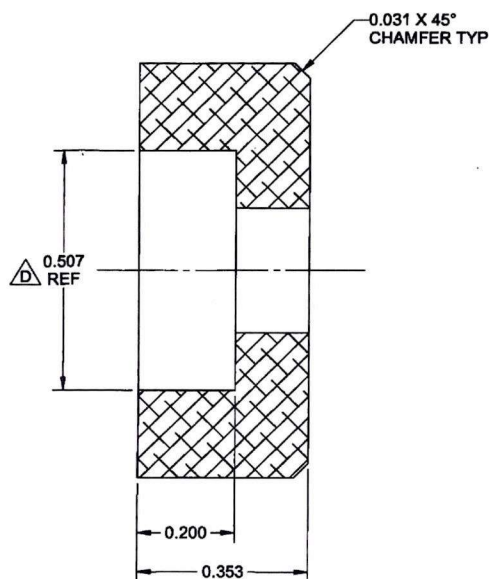
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B

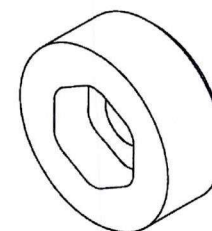
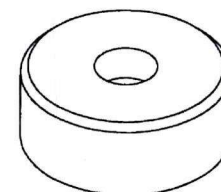
A



D4379-5 WEARPLATE CUP



SECTION C-C



D

C

B

A

NOTES:

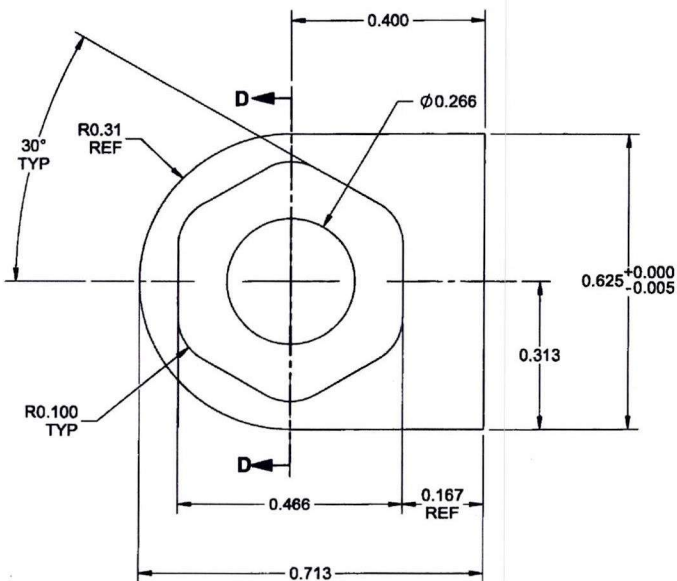
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

RELEASED
2016-02-23

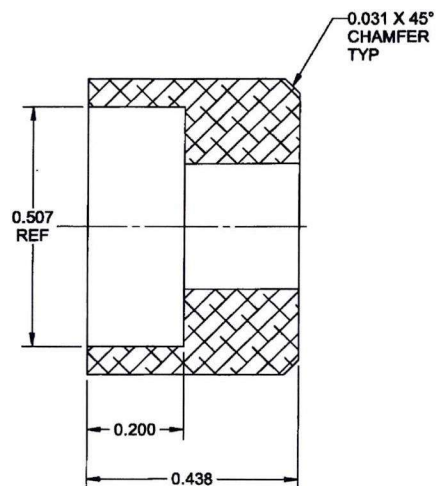
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JLM	D4379	SHEET 3 OF 4
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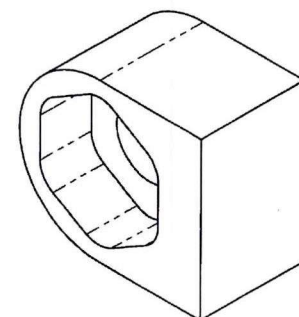
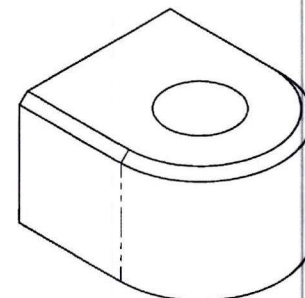
8 7 6 5 4 3 2 1



D4379-7 WEARPLATE CUP $\triangle$



SECTION D-D



NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
PER ASTM A276 OR ASTM A240
REF. DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

RELEASED
2016-02-23

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4379	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE CUP	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S146059



Part: D4379-5

Job No: 188974

Serial No/Batch: S146059

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/20/19